

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022652**Date Inspected:** 31-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Goodwin Steel, UK**Location:** Trentham, UK

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Cable Band				

**Summary of Items Observed:**

The following report is based on METS observations at Trentham UK on this date:

The QA Inspector observed set up and welding of Casting GG29439-1, Drawing Number 5540-B10-1-M. The welding was being performed by Mr. M. Edwards. Mr. Edwards was using WPS 04-0120F4G Issue 6. The welding was being performed at 27 volts and 187 amps. The heat input and the travel speed were being monitored. The filler metal was AWS A5.20 E71T-1M. The shielding gas was BOC Argon-shield Heavy. These are within the allowable range of the WPS. Welding was being performed in the 1G position.

The QA Inspector did verify the following for the cable band for Panel Point 22 West Bound, consisting of casting ~It was demonstrated that the Cable Band halves fit up with all bolt holes, keys and Suspender grooves aligning. ~It was demonstrated that ends of the Cable Band halves that exceed the length tolerance are flush/coincident with the rope grooves are aligned in the correct position. ~A dimensional check was performed in the presence of the Engineer's on-site representative. The results will be documented in the documentation package with the Certificate of Compliance.

The QA inspector did periodically observed dressing of the cable band for East Panel Point 40 consisting of castings GG29444-2, and GG29445-2. This is a B13 type 2 cable band. The suspender rope grooves are being ground. The dressing is being performed by Goodwin International Personnel.

The QA inspector did periodically observed dressing of a weld repair on cable band G29451-2, This is a B16-1-F casting. Excavation 4R on weld excavation map R2 is being ground to finish condition. The dressing is being

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performed by Goodwin International Personnel.

The QA inspector reviewed a copy of the Goodwin Steel Castings “Weld Excavation Map” for casting GG29429-11(R7), B7-1-F. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This eighth repair cycle is a major repair and requires post weld heat treatment. Caltrans Lot Number B243-089-11 was assigned for tracking purposes.

The QA inspector reviewed a copy of the Goodwin Steel Castings “Weld Excavation Map” for casting GG29448-3(R1), B15-1-M. The Weld Excavation Map was reviewed for accuracy and compliance with contract documents. This second repair cycle is a minor repair and does not require post weld heat treatment. Caltrans Lot Number B243-088-11 was assigned for tracking purposes.

The QA Inspector met with Goodwin International personnel Mr. Chris Ryder. This QA inspector received and reviewed the Advice of Despatch (Shipper). Copies of the Completed partial documentation packages for the Cable Band Assemblies had been previously reviewed. The documents contained the following: Material test reports, nondestructive testing reports, and Certificates of compliance from Goodwin Steel Foundry. Except as noted below, the material noted below appeared to be in conformance with the contract documents.

a. West Panel Point 26. The record of post weld heat treatment for repair R3 is not included in the partial documentation package. Mr. C. Ryder has been made aware of this.

b. East Panel Point 28. RFI 2091 applies to this cable band

A Green tag with blue dot with lot number B248-085-11 was assigned for the cable band for West Panel Point 26 and for the cable band for East Panel Point 28.



## Summary of Conversations:

Relevant conversations are documented above.

Nina Choy, (510) 385-5910

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Riegler,Randy	Quality Assurance Inspector
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer

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